

Work Order ID 60715

Tuesday, July 20, 2010 12:48:00 PM



Page 1

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 7/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-7-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev D								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114
2-Turn first side as per Folio FA114
3- File transition lines smooth.

Q.M. 10-07-26

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

Q.M. 10-07-26

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA114
2- File transition lines smooth.
3-Remove sand and plugs
4- scribe batch # and part # as per dwg

Q.M. 10-07-26

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00				Q11	10	-07-26	Q
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				70			
150  HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo Chemical Conversion Coat as per within 24 hours of machining	0.00 0.00				1K	2	MB-20-07-28	

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Page 3

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Start Date: 7/20/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/27/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11/07/28

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack
Location: X-tube cd

10 10-07-28

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28

10-7-28

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Picklist Print

Tuesday, July 20, 2010 12:48:06 PM

Page 1

Work Order ID: 60715



Parent Item: D212-664-201TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 7/20/2010

Required Date: 7/27/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6006-129		Manufactured	No			120	Each	41.0000	1	1			
Crosstube Material													

am 10-07-2010

Location

Loc Qty

Loc Code

LG

41

23970

2

26550

14

34690

11

38338

14

1

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 60715
Description: Crosstube Assembly (205/212 High Aft)	Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	/		vern	Am-04
	R0.063	+/-0.010	R0.063	/		R-g	
	2.990	+0.005/-0.000	2.991	/		vern	
	5.237	+/-0.030	5.237	/		"	
	2.600	+0.005/-0.000	2.605	/		"	
	2.686	+0.005/-0.000	2.681	/		"	
	2.770	+0.005/-0.000	2.775	/		"	
	2.854	+0.005/-0.000	2.859	/		"	
	2.938	+0.005/-0.000	2.943	/		"	
	3.021	+0.005/-0.000	3.026	/		"	
	3.133	+0.005/-0.000	3.137	/		"	
	3.179	+0.005/-0.000	3.184	/		"	
SIDE B	0.200	+/-0.010	0.200	/		vern	Am-04
	R0.063	+/-0.010	R0.063	/		R-g	
	2.990	+0.005/-0.000	2.991	/		vern	
	5.237	+/-0.030	5.237	/		"	
	2.600	+0.005/-0.000	2.605	/		"	
	2.686	+0.005/-0.000	2.691	/		"	
	2.770	+0.005/-0.000	2.775	/		"	
	2.854	+0.005/-0.000	2.859	/		"	
	2.938	+0.005/-0.000	2.943	/		"	
	3.021	+0.005/-0.000	3.026	/		"	
	3.133	+0.005/-0.000	3.137	/		"	
	3.179	+0.005/-0.000	3.184	/		"	
	124.36	+/-0.020	124.360	/		Tape measure	Am-01

Measured by: C. H.	Audited by: S	Prototype Approval:	N/A
Date: 10.07.26	Date: 10/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	

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Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60715

BS10-7-20

RELEASED
2009-10-29
AM

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C8-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-048 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	PH		
CHECKED	RF		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	09.09.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-241	REV. D SHEET 1 OF 4
TITLE CROSSTUBE ASSY (205/212 HI AFT)	SCALE NTS
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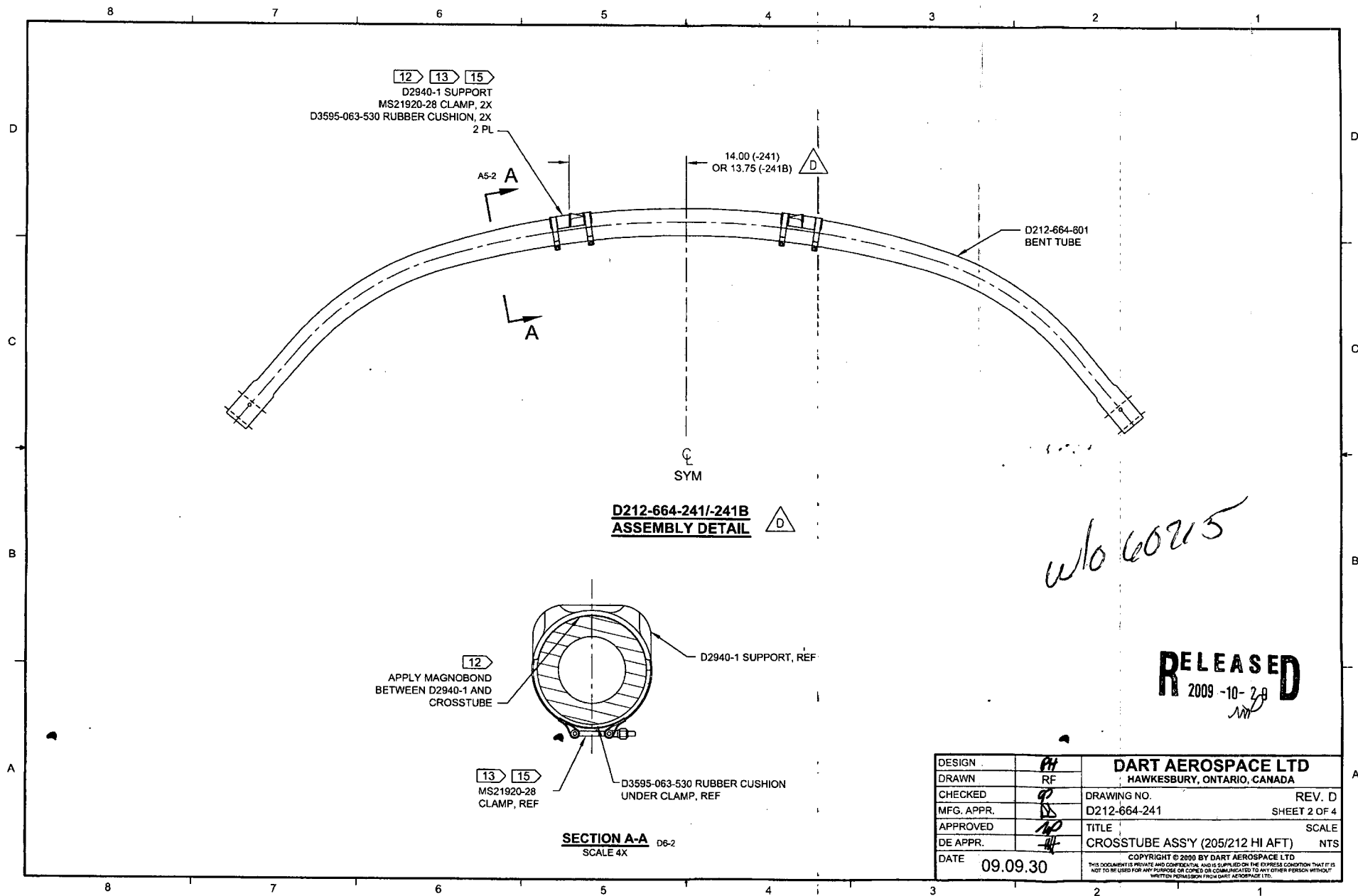
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DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	AS	D212-664-241	SHEET 2 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	AL	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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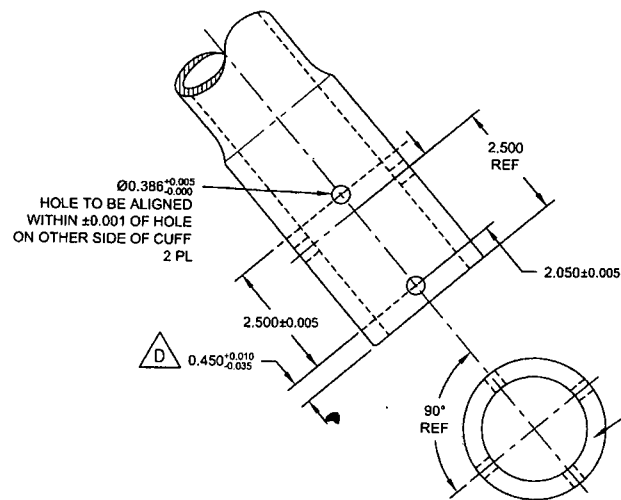
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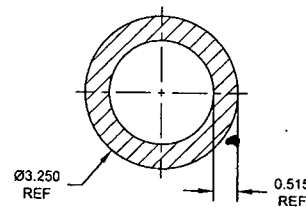
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D212-664-601 10 D
BENDING AND DRILLING DETAIL



VIEW C-C: CUFF DETAIL D2-3
 SCALE 3X



SECTION B-B D4-3
 SCALE 4X

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-241	SHEET 3 OF 4
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w/0 60715

RELEASED
 R 2009-10-29
MD

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